

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004053**Date Inspected:** 06-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A
Bridge No:	34-0006	Component:	OBG Fabrication	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Heavy Tower Bay #3:

ZPMC QC representative Mr. Shen Xue Jun provided the QA with a list of six closed rib deck panels that are ready for final visual weld inspections. Mr. Jun said ZPMC and ABF representatives have already completed their final visual inspections of the deck panels. The following deck panels were listed: DP571-001, DP563-001, DP557-001, DP596-001 and DP572-001 was listed twice. The QA Inspector asked Mr. Shen Xue Jun why DP572-001 was listed twice. Mr. Jun asked the ZPMC shop foreman this question and the foreman said these two deck panels will later be welded together and become one single deck panel. The QA Inspector performed random visual inspections of the closed rib welds on six deck panels and determined the deck panels appear to comply with project specifications. The QA Inspector documented the visual inspections on the yellow inspection status tag that is attached to each of the deck panels. Below is a photograph of a typical yellow inspection tag that is attached to deck panel DP572-001.

OBG Assembly Bay #2

The QA Inspector performed ultrasonic inspection of completed welds on deck panel DP060-001 to locate

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

potentially cracked tack weld locations. QA observed 1 of 90 welds that were inspected requires additional evaluations with the phased array ultrasonic technique to determine if the weld contains a crack.

SFOBB QA VERIFICATION TAG
IN-PROCESS

SUBASSEMBLY DP572-001A (2AW) Tag No. 000664

INSPECTIONS					REPAIRS					
EVT	MC	ABF	CT	Dimen	ZPMC	ABF	CT	CWR	HSR	NCR

Notes: Initial VT = Summary 1/19/08 B25 9/1/08 ABF 01/08

DP572-001A tag 04-0120F4 16:03 09-06-08

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
